



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3594-043
Job Sheet 175488



Part No: D3594-043

Job Qty: 8 ea

Part Name: Floor Doubler Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/5/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 3,4 IPP Rev :A New Issue 07-01-22 EC IPP REV:B 16.07.28 DWG REV.C DD
VERF:JLM IPP REV:C 17.04.27 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		4/28/18	0.00	0.00	Start Up Waterjet		OK 18/04/07
100	Waterjet	8 pcs		4/28/18	0.00	3.31	Waterjet1		OK 18/04/07
110	QC	8 pcs		4/28/18	0.00	0.00	QC2 Waterjet-2		OK 18/04/07
120	QC	8 pcs		4/28/18	0.00	0.00	QC8-3		38
130	Small Fab	8 pcs		4/28/18	0.00	0.42	Small Fab-4		9-89 DAS
140	QC	8 pcs		4/28/18	0.00	0.00	QC5		38
150	HandFinish	8 pcs		4/28/18	0.00	0.27	HandFinish1		SA 18-04-18
160	QC	8 pcs		4/28/18	0.00	0.00	QC7-2		
170	Small Fab	8 pcs		4/30/18	0.00	0.42	Small Fab-4		DAS
180	QC	8 pcs		4/30/18	0.00	0.00	QC5		DAS 38
190	Packaging	8 pcs		4/30/18	0.00	0.00	Packaging3-1	5/303	6-89 APR 24 2018
200	QC21-SA	8 Ea		4/30/18	0.00	0.00	QC21		9-89 APR 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	4.0800 sf (.51 ea)	90-Start up Operation	
MS20426AD4-4	Rivet	16 Ea (2 ea)	170-Small Fab	F125445-4
MS21069-5	Anchor Nuts	8 Ea (1 ea)	170-Small Fab	5050043

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	4	197	0
170-Small Fab	MS20426AD4-4	16	1,655	0
	MS21069-5	8	40	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																
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Date : _____			MRB (QSI042) Approval																																																	
Descript			Completed By																																																	
DART Aerospace Ltd. 1270 Aberdeen Street Hamilton, ON K6A 1K7 CANADA TEL: 1 813 892-5200 Email: sales@dartaero.com www.dartaero.com Date: 04/07/18 Container No: S059001 Part: D3594 - 043 Job No: 175488 Serial No/Batch: S059001 Revision: _____ Inspector: _____			Lead hand / Supervisor Approval Verification																																																	
Root Cause <table style="width:100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re ☐</td> <td style="border: none;">Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Opera ☐</td> <td style="border: none;">rogram ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset, ☐</td> <td></td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;">Cracks ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> <td colspan="2" style="border: none;"></td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> <td colspan="2" style="border: none;"></td> </tr> </table>			Environment ☐	No Re ☐	Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Opera ☐	rogram ☐	Outside Dimensions ☐	Doc/Data ☐	Offset, ☐		Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐			OTHER :	
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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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